

Date: Monday, 02/03/2009 11:25:47 AM
 User: Julie Dawson

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR DOUBLER
Job Number	: 46196-2	Part Number	: D3594043
Estimate Number	: 12681	Drawing Number	: D3594 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 02/03/2009 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 16/03/2009
Previous Run	: 45194	Qty:	5 Um: Each
Written By	:		
Checked & Approved By	: JUD 09.03.02		
Comment	: Est Rev :A New Issue 07-01-22 EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 4.2840 sf(s)

6061-T6 .080 Sheet

Batch: 111003

ml 09 03 06 (8)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

ml 09 03 06 (8)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 03 06

(8)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Scallos 66 (x8 -3)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

4/09/03/09 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:47 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 46196

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/09

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

cmd/BK

09/03/09

(X8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 09/03/09

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Anchor nuts

BATCH: M107938

(5X)

09/03/09

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Rivet

BATCH: M15541

09/03/09

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

09/03/09 (5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/09

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9/3/10

(5)

SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:47 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 46196

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

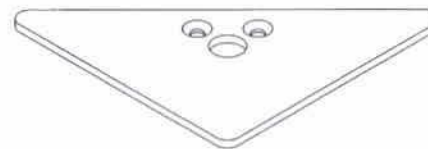
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

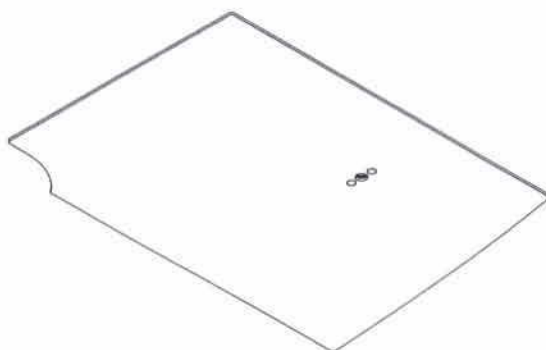
NOTE: Date & initial all entries



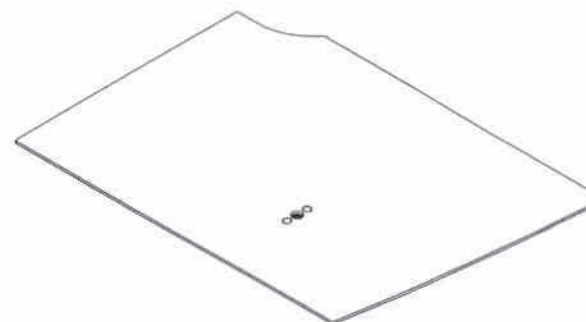
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



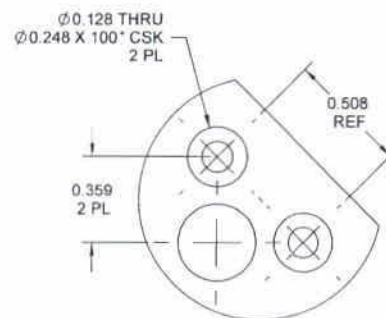
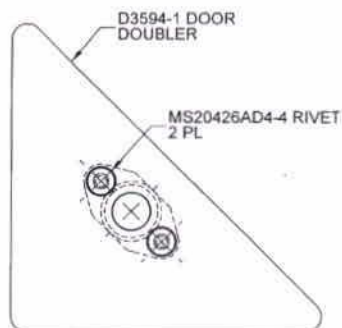
D3594-044 FLOOR DOUBLER ASSEMBLY

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08.05.14

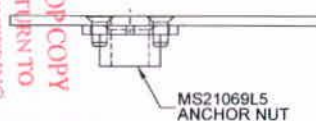
B	REFORMAT TO B SIZE DRAWING, SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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WORK ORDER
NO. 4094

QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK

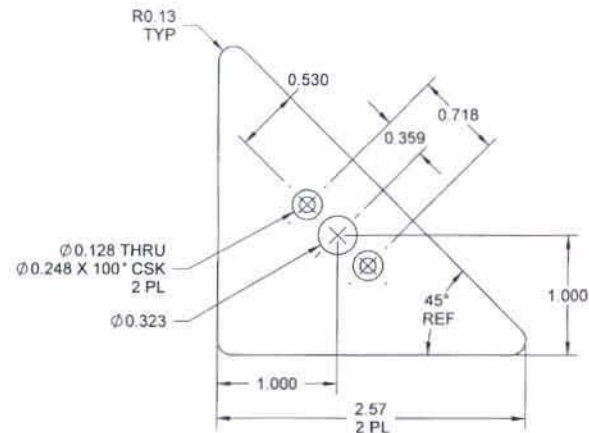


DETAIL A
SCALE 2X

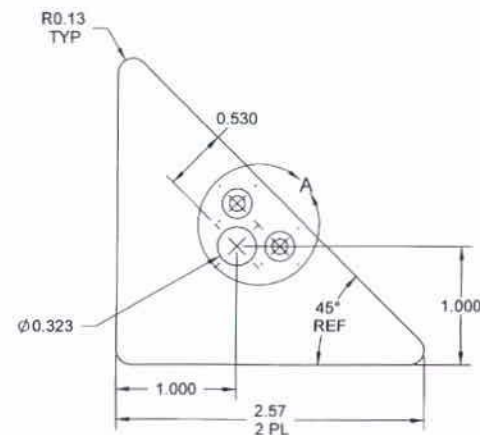


MS21069L5
ANCHOR NUT

4 D3594-041 DOOR DOUBLER ASSEMBLY



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

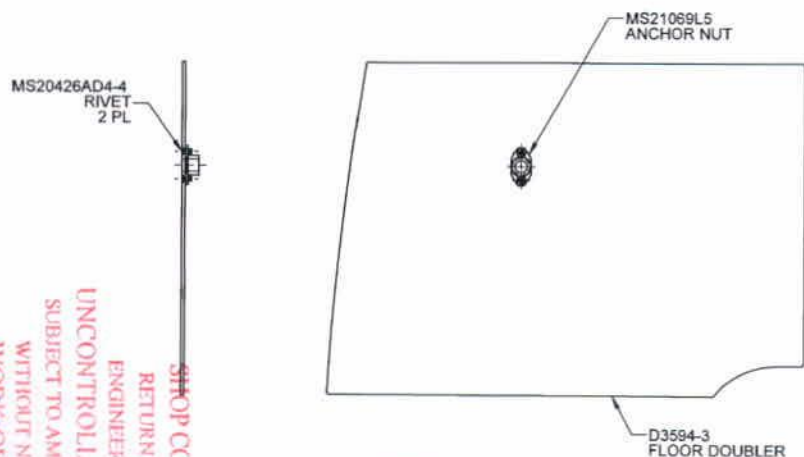
RELEASED
28 DEC 26 1970

NOTES:

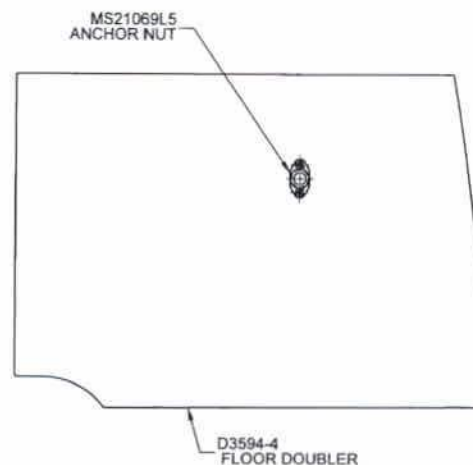
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE DOUBLER	SCALE NTS
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DATE	08.05.14		

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

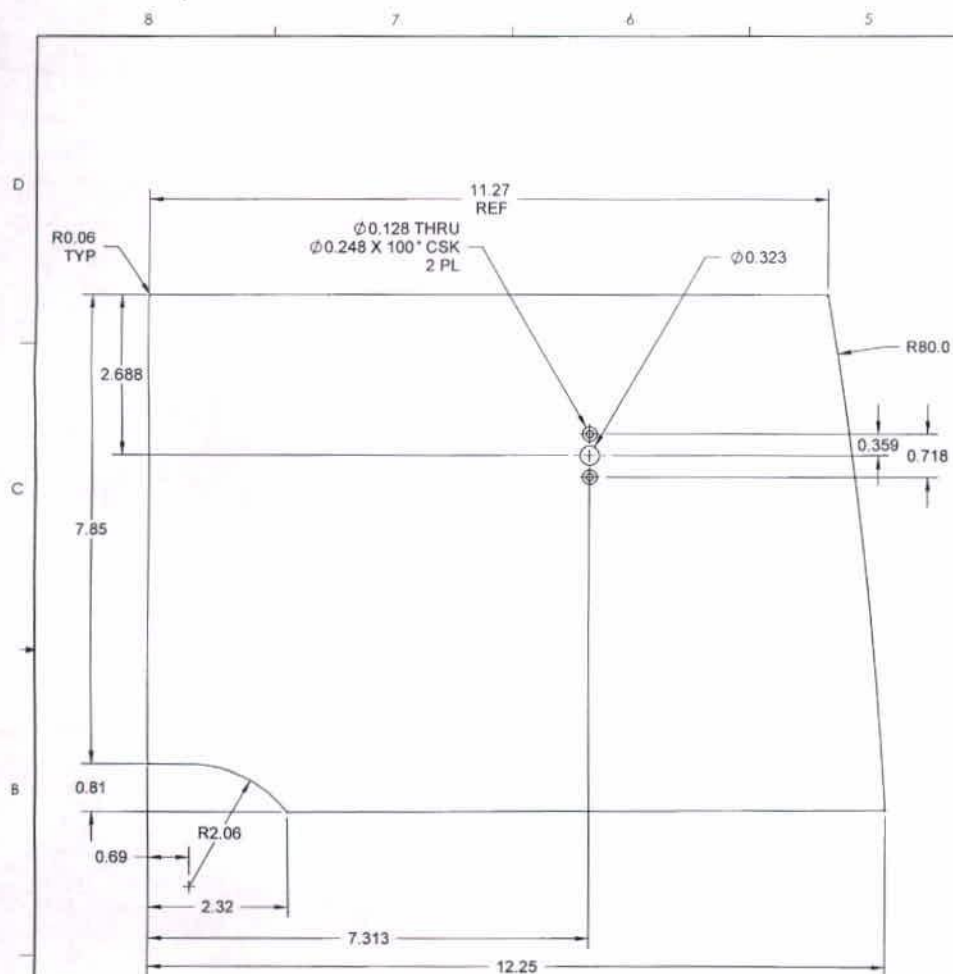
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

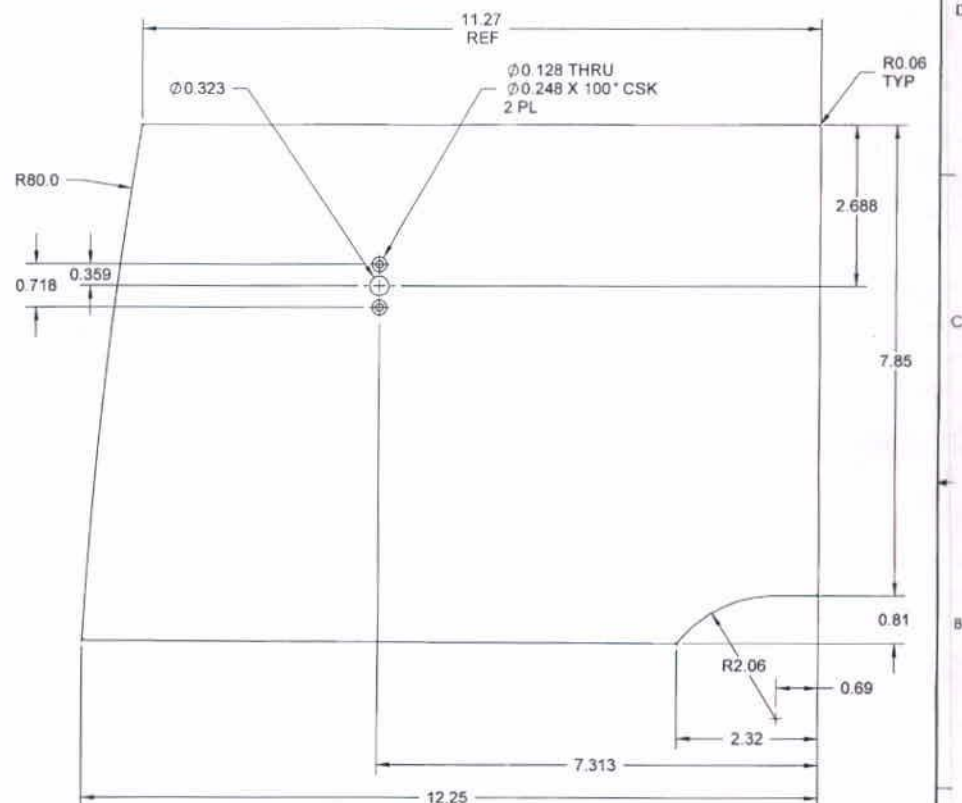
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D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

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CHECKED	<i>[Signature]</i>	DRAWING NO. D3594	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	DOOR DOUBLER ASSEMBLY	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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